

Date: Wednesday, 10/11/2006 12:49:53 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG EXTRUSION
 Job Number : 28936
 Estimate Number : 10326
 P.O. Number : N/A Part Number : D27317
 This Issue : 10/11/2006 S.O. No. : N/A Drawing Number : D2731 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 28074 Material : N/A
 Due Date : 10/30/2006 Qty: 50 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature] 06/10/11
 Comment : Est D 00.0518 Added inspect level 8, removed P/O powder coating EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty: 0.0717 f(s)/Unit Total: 3.5858 f(s)

Lug Extrusion D2423

Batch: D2423 B23779

MS 06/10/11

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 extrusion to .82"

Batch D2423 B23779

MS 06/10/11

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2731-7

2-Check for crack while loading into the machine.

3-Tumble

4-Deburr any rough edges after tumbling

machine per drawing D2731 Rev. B

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

damage 06/11/03 (50)

5.0 QC6 SECOND CHECK



Comment: SECOND CHECK

06/11/13 (50) counted

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 12:49:54 PM
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Drawing Name: LUG EXTRUSION

Job Number: 28936

Part Number: D27317

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FC
4/ 06/11/13 x 50

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

FC
M102 391
4/ 06/11/27 x 50

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 4/11/28 (50)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57148
FC 4/11/28 (50)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(50)
06/11/28

Job Completion



C Loc 11/128

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/11/28
 QA: N/C Closed: _____ Date: _____

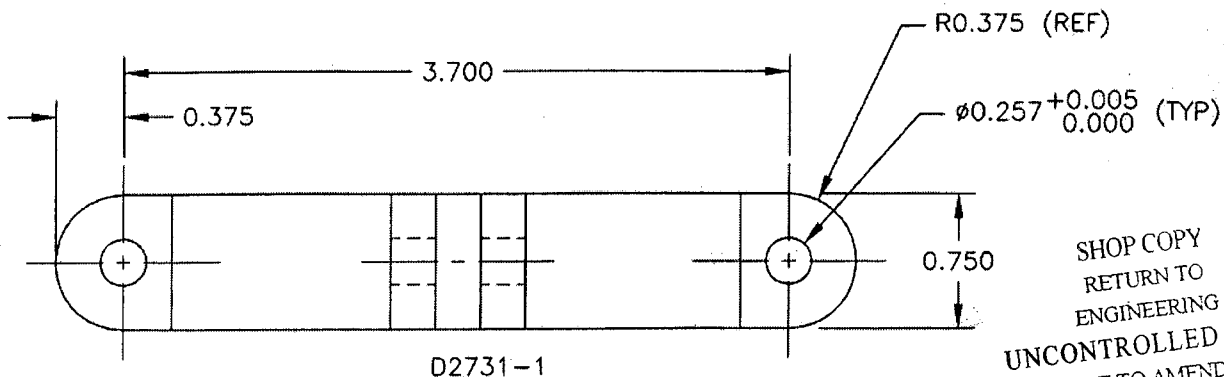
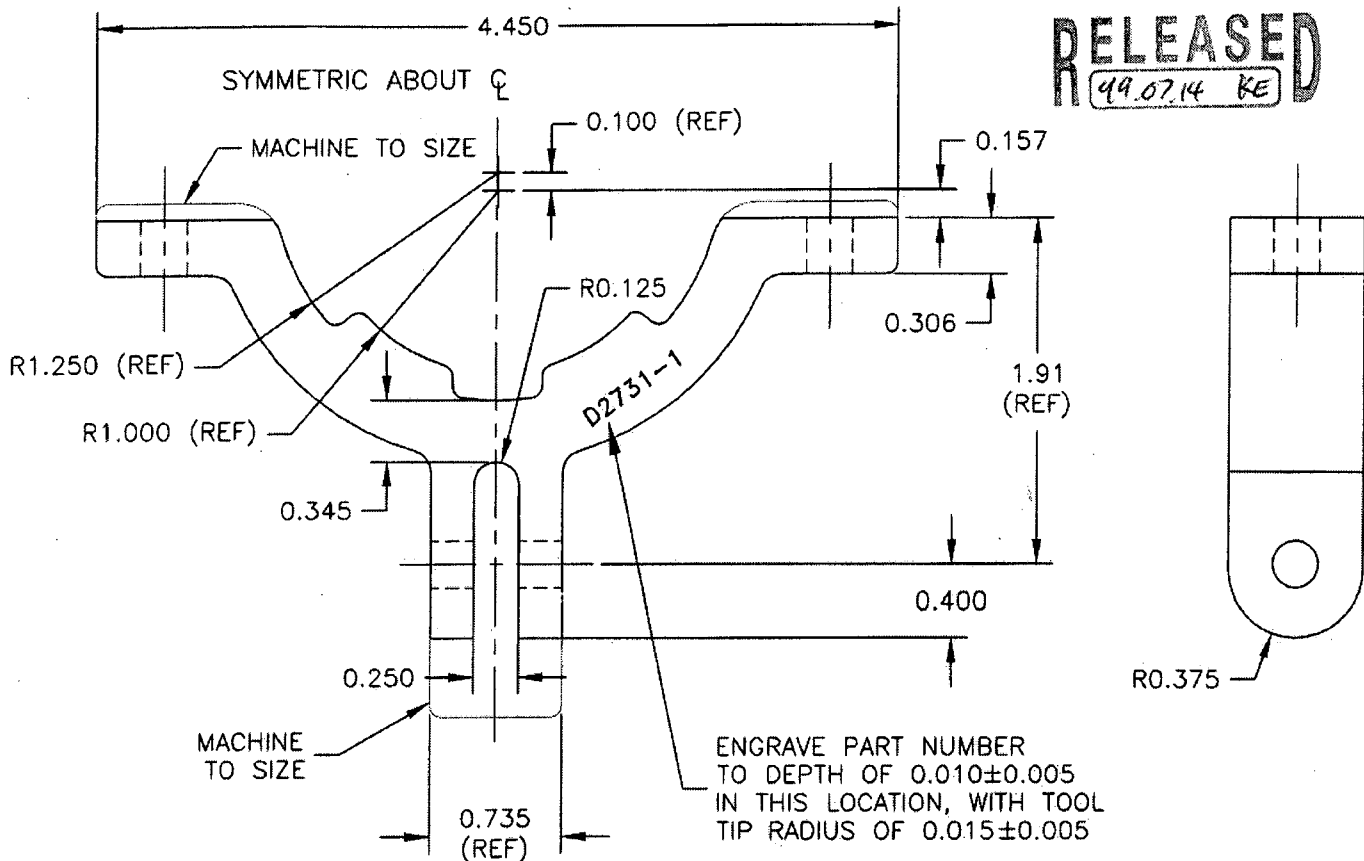
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	

RELEASED
49.07.14 KE



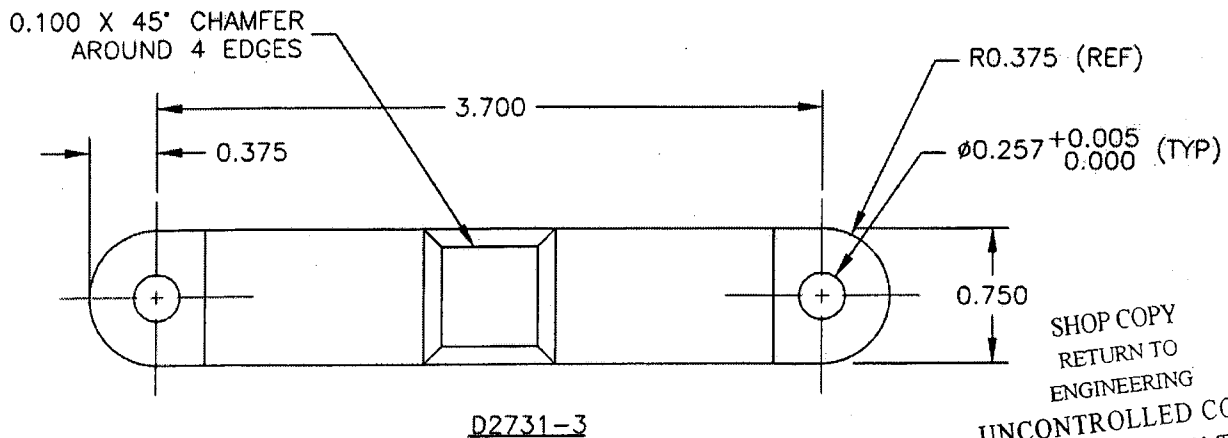
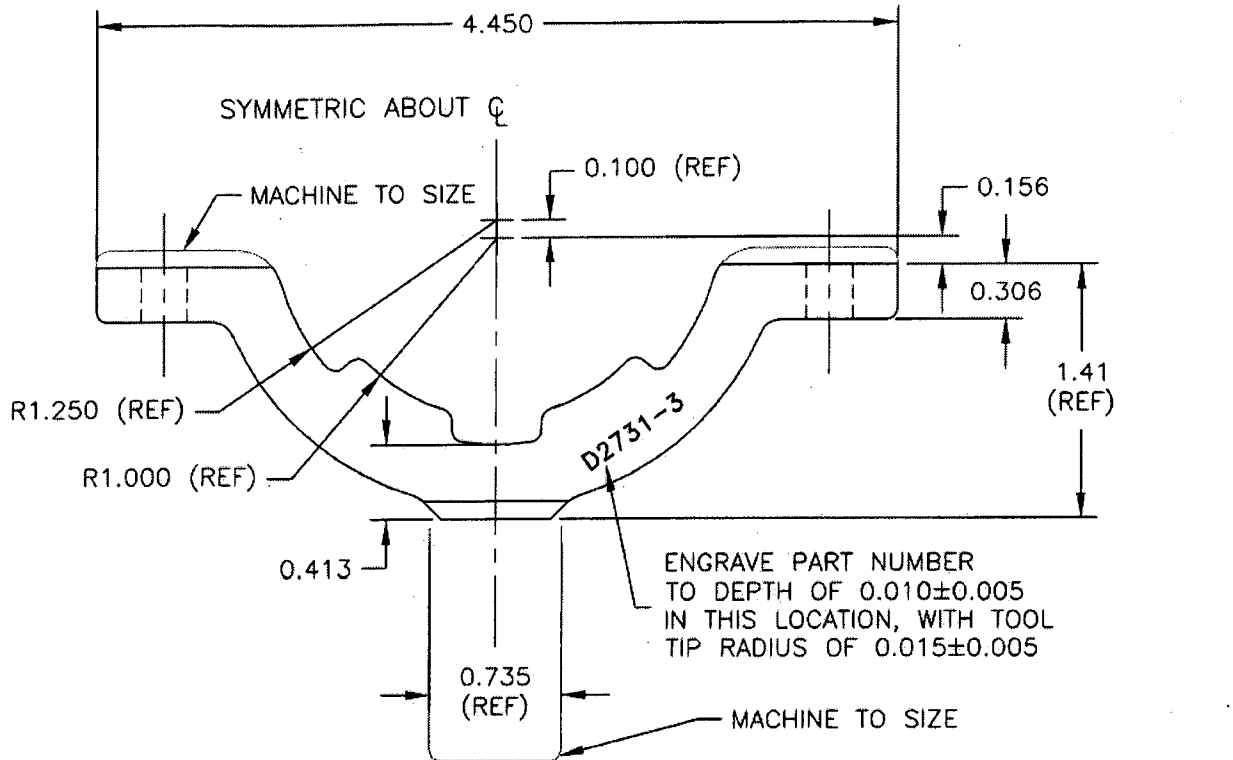
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28936



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DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *KE*



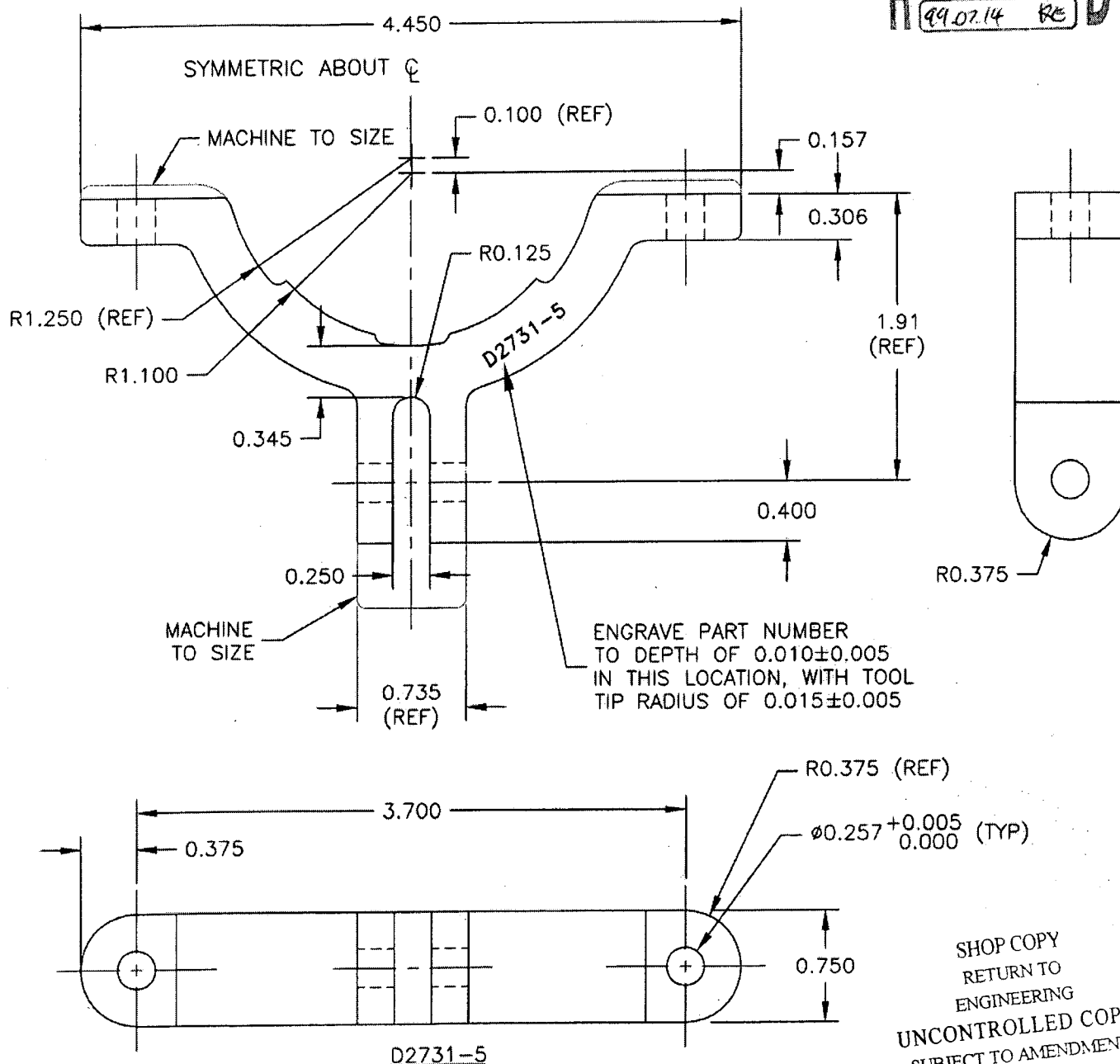
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DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *RE*



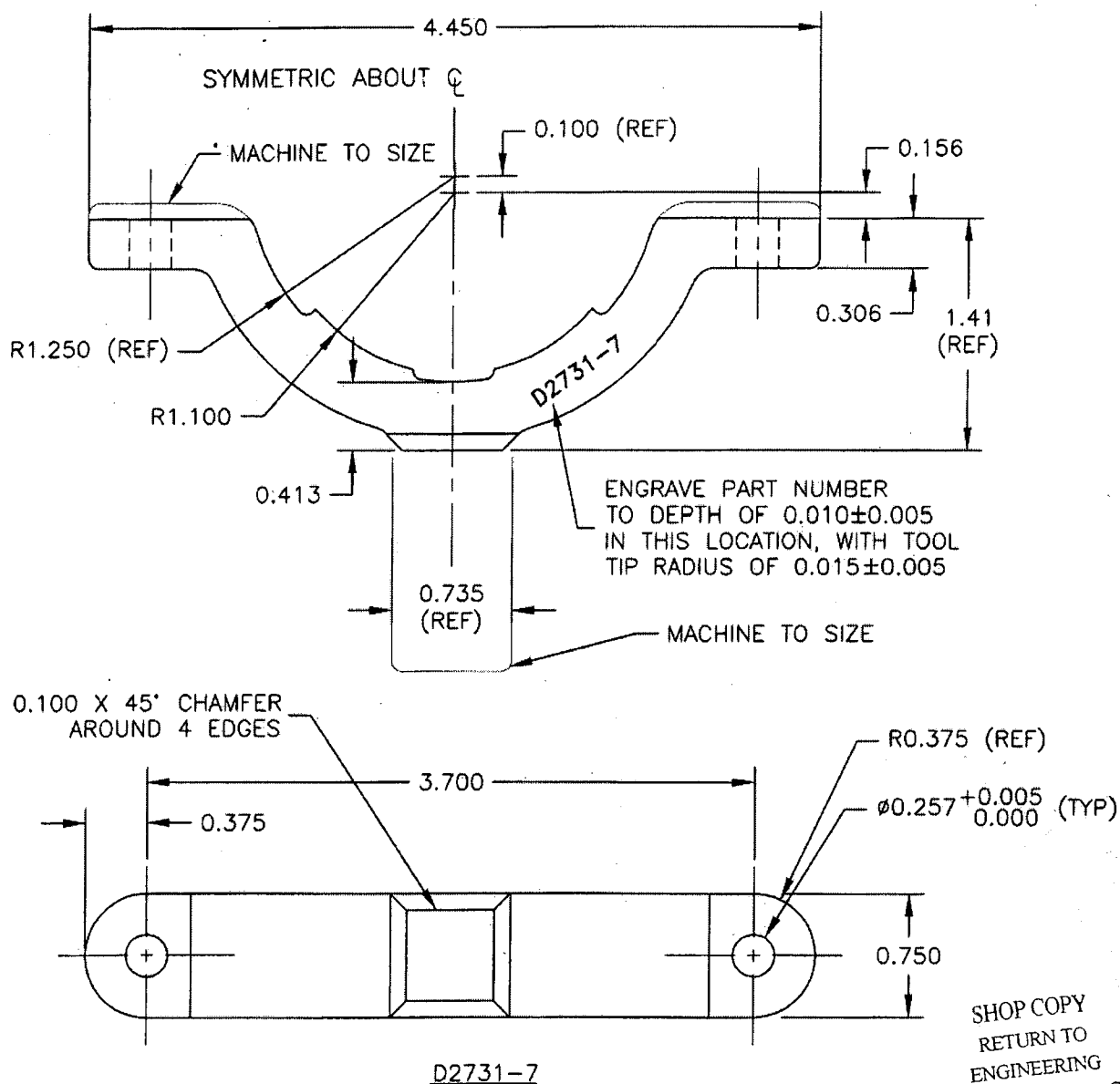
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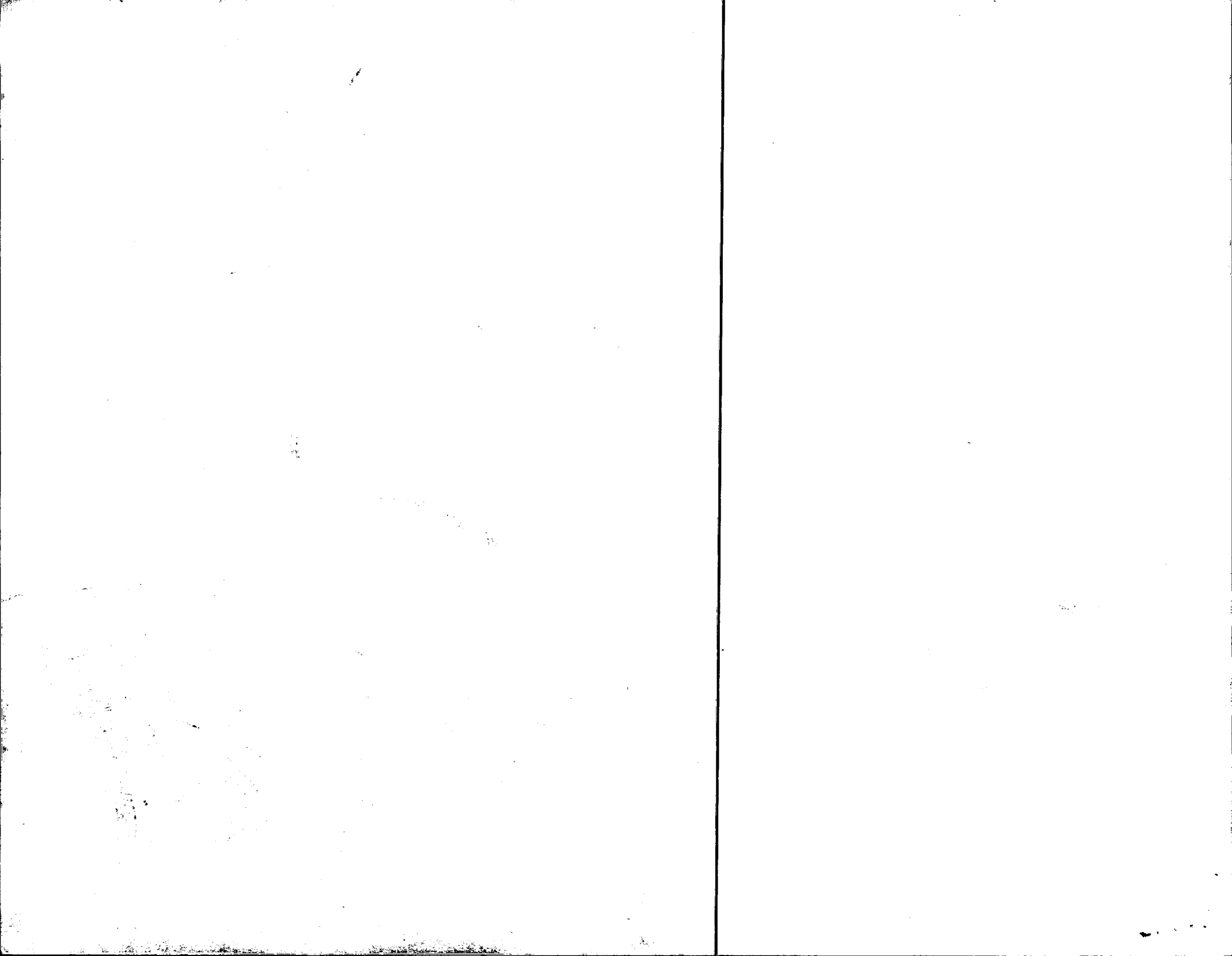
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DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

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99.07.14 *KE*



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NO. 28936





CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

50

D 2731-7

Lug

PO00002231

MATERIAL: supplied by DART D2423 B23779 B28936 ✓

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Denise Robinson

Vankleek Hill, November 2, 2006

